

**Aero Design Ltd.****Work Order Control Sheet**Work Order#: 2017-200 Date Opened: 17 Nov. 17 Title: AssemblyAircraft OEM: Bell Aircraft Model: 407 Product Type: Cargo Basket Product Model: High Ski Quantity: 1**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)  
Additional Work Sheets (Standard Practice)  
Drawings (See List Below)  
Parts Distribution Sheet  
Sub Component Tags  
Completed Certification  
Time Sheet (R&D)  
Notes

Initial or N/A

|       |
|-------|
| CB/JC |
| N/A   |
| CB/JC |
| CB/JC |
| JC    |
| JC    |
| N/A   |
| N/A   |

**Build Sheet Contents**

Tasks Initialled  
Dual Inspections Initialled

Initial or N/A

|       |
|-------|
| CB/JC |
| CB/JC |

**Drawing List**

| Drawing # | Rev # | Description            | Initial or N/A |
|-----------|-------|------------------------|----------------|
| 76610     | 1     | Basket                 | CB/JC          |
| 76627     | 1     | Placard                | CB/JC          |
| 70405     | 4     | Lid Walkway            | CB/JC          |
| 84255     | 2     | Handle Installation    | CB/JC          |
| 84240     | 0     | Lid Brace Installation | CB/JC          |
|           |       |                        |                |
|           |       |                        |                |

**Traveller**

Install walkway on lid  
Install lid on basket body  
Re-tap mounting lug holes and install mount lugs  
Install handle brackets  
Install handle  
Install lid prop  
Install data plate

Initial or N/A

|       |
|-------|
| CB/JR |
| CB/JR |
| JR    |
| JR    |
| JR    |
| JR    |
| CB/JR |

**Component Completion**

Quantity Complete on This Work Order  
Quantity Incomplete on This Work Order  
Further Processing Required Before Release  
Release to Stock as Components

As Instructed

|     |
|-----|
| 1   |
| N/A |
| N/A |
| N/A |

**Certification**

Form One Completed  
Serviceable (Green) Tag Completed  
In Process (Yellow) Tag Completed  
Unserviceable (Red) Tag Completed  
Parts Placed in Stores for Distribution

Initial or N/A

|     |
|-----|
| JC  |
| N/A |
| N/A |
| N/A |
| N/A |

**Additional Documentation**

Documentation of a minor change  
Non-Conformance Report Required  
Service Difficulty Report Required

Initial or N/A

|     |
|-----|
| N/A |
| N/A |
| N/A |

**Billing**

Local (Aero Design)  
Research and Development  
Third Party

Initial or N/A

|     |
|-----|
| JC  |
| N/A |
| N/A |

Work performed by:

Print: C. Brander J RekveSign: SCA: AD01Date: 22-Nov-17

ICC / Dual Inspection performed by:

Print: J. ClarkeSign: SCA: AD02Date: 22-Nov-17

Work Order closed by:

Print: C. Brander J. ClarkeSign: SCA: AD02Date: 23-Nov-17

Approved Manufacturing Facility 73-04

Form 20.D.03

Rev. Original 23 Sep 2014



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

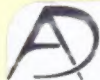
Nomenclature: Handle Bar Assy No. of pieces: 1  
Manufacturer: Aero Design  
Part No.: 84261 - 01 Serial/Batch No.: NSN  
TTSN: N/P TSO: N/A Rem.: N/A  
Work Order No.: 2017 - 194  
Remaining Tasks to be Performed: To be installed

Signature: [Signature]

Date: Nov 21/2017

Lic. No. / SCA AD 73-04 05

Serviceable



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

Quantity: 1

PN: MS20001P4-9600

Aircraft: All

Model: All

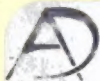
Description: Hinge

Supplier: GKN Aerospace Bandy Machining

Color: N/A

WO#: N/A

PO# 17017



## **Aero Design Ltd.**

9888 A Malaspina Rd., Powell River, BC  
V8A 0G3, 604-483-AERO (2376)

|              |                           |            |
|--------------|---------------------------|------------|
| Quantity:    | 1                         |            |
| PN:          | Tread Plate               |            |
| Aircraft:    | All                       | Model: N/A |
| Description: | Lid Walkway Checker Plate |            |
| Supplier:    | Ryerson                   |            |
| Color:       | Aluminum                  |            |
| WO#:         | N/A                       | PO# 17081  |



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: 407 Lid No. of pieces: 1

Manufacturer: Aero Design Ltd

Part No.: 76612-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-01

Remaining Tasks to be Performed: Clean up, Inspect,  
Powder Coat.

Signature: [Signature]

Date: Nov 6/2017 Lic. No. / SCA 73-04  
05

In Process



## Aero Design Ltd.

9888 A Malaspina Rd. Powell River, BC, V8A 0G3

Phone: 604-483-2376 Fax: 604-483-2372 E-mail: info@aerodesign.ca

AMF 73-04

Nomenclature: Bell 407 H.M. Body No. of pieces: 1

Manufacturer: Aero Design Ltd.

Part No.: 76611-01 Serial/Batch No.: NA

TTSN: NA TSO: NA Rem.: NA

Work Order No.: 2017-163-01

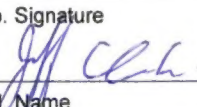
Remaining Tasks to be Performed: Clean up, Inspect,  
Powder coat.

Signature: [Signature]

Date: Nov 13/2017 Lic. No. / SCA 73-04

In Process



|   |   |   |  |   |  |
|---|---|---|--|---|--|
| 1. Approving Civil Aviation Authority/Country<br><b>Transport Canada</b>  |   | 2. AUTHORIZED RELEASE CERTIFICATE<br>FORM ONE         |  |   | 3. Form Tracking No.<br><b>2017-0428</b>             |
| 4. Organization Name and Address<br><b>AERO Design Ltd. – 9888A Malaspina Road, Powell River, BC, V8A 0G3</b>   |   |   |  |   | 5. Work Order/Contract/Invoice<br><b>WO 2017-200</b> |
| 6. Item<br><b>1.</b>  | 7. Description<br><b>Cargo Basket Ass'y</b> | 8. Part Number<br><b>76610-01</b>                     | 9. Qty.<br><b>1</b>  | 10. Serial/Batch No.<br><b>76601-33</b> | 11. Status/Work<br><b>New</b>                        |
| 12. Remarks<br><b>Modified with walkway on lid IAW DCL704</b>   |   |   |  |   |  |
| 13a. Certifies that the items identified above were manufactured in conformity to:<br><br><input checked="" type="checkbox"/> Approved design data and are in condition for safe operation.<br><input type="checkbox"/> Non approved design data specified in block 12.   |   |   | 14a. <input type="checkbox"/> CAR 571.10 Maintenance Release<br><input type="checkbox"/> Other regulation specified in block 12.<br>Certifies that unless otherwise specified in block 12, the work identified in block 11 and described in block 12, has been performed in compliance with the Canadian Aviation Regulations. |   |  |
| 13b. Signature<br> <b>AD 73-04 02</b>  |   | 13c. Approved Organization Number<br><b>AMF 73-04</b> |  | 14b. Signature                          |  |
| 13d. Name<br><b>Jeff Clarke - AD02</b>  |   | 13e. Date (dd/mmm/yyyy)<br><b>22 Nov 2017</b>         |  | 14c. Approved Organization Number       |  |
|   |   |   |  | 14d. Name                               |  |
|   |   |   |  | 14e. Date (dd/mmm/yyyy)                 |  |
| <p align="center"><b>Installer Responsibilities</b></p> <p>This certificate does not constitute authority to install.</p> <p>Installers working in accordance with the national regulations of a country other than that specified in block 1 must ensure that their regulations recognize certifications from the country specified.</p> <p>Statements in blocks 13a or 14a do not constitute installation certification. In all cases, the technical record for the aircraft must contain an installation certification issued in accordance with the applicable national regulations before the aircraft may be flown.</p> |   |   |  |   |  |

**ALPINE HELICOPTERS**

# CARGO BASKET ASSEMBLY - COMMON

Work Order: 2017-200

Date Open: 17 Nov. 2017

## General

These instructions apply to all cargo basket assemblies. Refer to the following drawings, at the current revision, for dimensions and details. Drawings are linked to the source for ease of printing.

| ✓                                      | Basket Type            | Basket                |                       |                       | Lid Walk              | Lid Prop              | Handle                |                       |                       |
|--|------------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|
|  |                        | Ass'y                 | Placard               | Mat'l                 |                       |                       | Inst'n                | Ass'y                 | Mat'l                 |
| Bell 206B – right side only            |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Short                  | <a href="#">80210</a> | <a href="#">80227</a> | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
|  | Medium                 | <a href="#">80310</a> | <a href="#">80327</a> | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
|  | Long                   | <a href="#">81110</a> | <a href="#">81127</a> | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
| Bell 206L/407 – Right side only        |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Low Standard           | <a href="#">69810</a> | <a href="#">69827</a> | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
|  | Low Wide               | <a href="#">94510</a> | <a href="#">94527</a> | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
|  | Low Ski                | <a href="#">94610</a> | <a href="#">94627</a> | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
|  | High Ski               | 76610                 | 76625                 | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
| Bell Medium – left or right            |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Standard               | 75110                 | 75127                 | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
|  | Extra Large (ski)      | 95510                 | 95527                 | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
|  | Mega                   | 100610                | 100627                | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
| Bell 429 – right or left               |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Standard – Pre S/N 71  | 95910                 | 95927                 | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
|  | Standard – Post S/N 71 | 95950                 | 95927                 | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
| Eurocopter AS350/AS355 – left or right |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Short                  | 77610                 | 77627                 | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
|  | Medium                 | 76410                 | 76427                 | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
|  | Long                   | 78410                 | 78427                 | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
|  | Ski                    | 94010                 | 94027                 | <a href="#">Mat'l</a> |                       |                       |                       |                       | <a href="#">Mat'l</a> |
| Robinson R44 – left or right           |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Standard               | 90610                 | 90627                 | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
| MD600                                  |                        |                       |                       |                       |                       |                       |                       |                       |                       |
|  | Standard               | 82810                 | 82827                 | <a href="#">Mat'l</a> | <a href="#">70405</a> | <a href="#">84240</a> | <a href="#">84255</a> | <a href="#">84261</a> | <a href="#">Mat'l</a> |
|  |                        |                       |                       |                       |                       |                       |                       |                       |                       |

Hyperlinking to specific excel sheet –

1. on desired excel sheet cell A1, set name of cell, eg. Assembly.
2. at end of hyperlink add #Assembly (filename.xls#Assembly).



CR

## 1. Lid Assembly

## a. Install lid bumpers on bottom.

- i. Drill  $\frac{1}{4}$ " holes using center drill, 3 (standard/medium) or 4 (long/ski) places.
- ii. Fill bumper holes with RTV silicone sealant.
- iii. Insert 49205-14 lid bumper, 3 or 4 places per lid.

## b. Install placard on bracket on top of lid

Note: 959 and 1006 placard is installed on body.

- i. Locate placard on bracket.
- ii. Drill #30 through placard and bracket, using holes in placard.
- iii. Remove placard and de-burr holes in placard and on bracket.
- iv. Locate placard on bracket, and cleco in place.
- v. Rivet placard with four CR3213-4-02 CherryMax rivets.

## c. Option: Install walkway on top of lid (lid must be fitted with walkway provisions)

- i. Note: avoid touching surface of tread plate with bare hands to prevent smudges or marks on the top surface.
- ii. Pull tread plate from stock. Shear tread plate to length.
- iii. De-burr edges of tread plate with scotch-brite wheel on bench grinder.
- iv. Locate tread plate on lid. Hold tread plate in place with bags of lead shot.
- v. Mark and drill #30 holes:
  1. 0.25" from edge of tread plate, centre on cross members (0.38")
  2. 0.25" from edge of tread plate, middle of each walkway stringer
- vi. De-burr and counter-bore (if required to provide clearance of rivet head on checker pattern) all holes in tread plate using  $\frac{1}{4}$ " piloted counter bore on both sides.
- vii. De-burr holes in lid tubes.
- viii. Apply bead of RTV silicone sealant along all tubes under tread plate.
- ix. Set tread plate in place, secure with clecos if necessary.
- x. Rivet placard with CR3213-4-02 CherryMax rivets

## d. Record PO/WO of all parts (including lid) used in steps above on attached material tracking list.

## 2. Body Assembly

## a. Install attachment fittings

- i. Carefully remove excess powder coat from around attachment lug threads using a countersink.
- ii. Run 3/8-24 tap into attachment lugs to clear threads.
- iii. Apply anti-seize compound to attachment fittings 96710-01 (alternate: Ancra 40088-14)
- iv. Install attachment fittings with two NAS1149F0363P washers in four lugs in basket.
  1. 90610 (Robinson R44) basket only:
    - a. Install 1 fitting 90628-01 in lower forward attachment lug only.
    - b. Install 3 96710-01 fittings in remaining locations.
- v. Torque to 160-190 in-lbs (13.3-15.8 ft-lbs).

- b. 959 and 1006 Baskets only: Install inboard sheet on upper rim of basket
- Locate sheet on basket.
  - Drill #30 through sheet and rim, located as specified on drawing. Cleco in place.
  - Remove sheet and de-burr holes in sheet and rim.
  - Apply bead of RTV silicone sealant along all tubes under sheet.
  - Locate sheet on basket, and cleco in place. *N/A*
  - Rivet sheet with CR3213-4-02 CherryMax rivets.
- c. 959 Basket only: Install forward sheet
- Locate sheet on basket. Ensure sufficient clamps are in place. *N/A*
  - Drill #30 through sheet, rim and hoop, located as specified on drawing. Cleco in place.
  - Remove sheet and de-burr holes in sheet and rim.
  - Apply bead of Pro-Seal sealant along all tubes under sheet.
  - Locate sheet on basket, and cleco in place.
  - Rivet sheet with CR3213-4-02 CherryMax rivets.
- d. Record PO/WO of all parts (including basket) used in steps above on attached material tracking list.

### 3. Hinge Installation *CB*

- a. Prepare hinge.
- Cut hinge to length:
    - 776, 906 – 54"
    - 751, 803 – 70"
    - 698, 764, 945 – 72"
    - 766, 784 – 90"
    - 940, 946, 959 – 95"
    - 1006 – 107"
  - Drill #30 pilot holes using hinge jig. For long hinges, flip at specified location on jig.
- b. Install hinge on basket
- Locate hinge on basket (standard baskets)
    - centre fore/aft
    - 0.15" – 0.18" up from bottom edge
  - Locate hinge on basket (extra wide baskets)
    - centre fore/aft
    - set hinge at 90 degrees (as if lid would be installed) using a small square, locate vertical side at 22.5" from outboard edge.
  - Drill #30 through holes in hinge into basket rim. Cleco in place with 1/8 (copper) clecos.
  - Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 (black) clecos.
  - Remove hinge and de-burr holes in hinge and basket rim.
  - Cleco hinge to basket with 5/32 clecos.
  - Install hinge with CherryMax rivets
    - CR3523-5-02 monel rivets – last 2 rivets in each end
    - CR3213-5-02 aluminum rivets – all other locations

- c. Install lid on basket
  - i. Locate lid on hinge (all baskets)
    - 1. center fore/aft
    - 2. 0.15" – 0.18" down from top edge
  - ii. Drill #30 through holes in hinge into lid rim. Cleco in place with 1/8 clecos.
  - iii. Drill holes up to #21 through hinge and rim. Replace 1/8 clecos with 5/32 clecos.
  - iv. Remove hinge and de-burr holes in hinge and lid rim.
  - v. Cleco lid to hinge with 5/32 clecos.
  - vi. Install hinge with CherryMax rivets
    - 1. CR3523-5-02 monel rivets – last 2 rivets in each end
    - 2. CR3213-5-02 aluminum rivets – all other locations
- d. Record PO of hinge and rivets on attached material tracking list.

#### 4. Install Handle

- a. Install handle brackets.
  - i. Set 84267-01 handle bracket on provisions in hoops, 2 places. *OK*
  - ii. Install AN3-11A bolt, NAS1149F0363P washer (2), MS21044N3 nut. Two places per bracket, two brackets per basket.
  - iii. Torque AN3 bolts to 20-25 in-lbs.
- b. Install handle
  - i. Trim 36278-01R and 36278-01L springs to ensure end of spring does not extend past edge of handle bracket, approximately 1/8". Set springs over bushing of 84261-01 handle assembly. *OK*
  - ii. Grease two 36275-01 bushings with Mobil Grease 28 or equivalent. Insert into bushings of handle assembly.
  - iii. Locate handle on basket lid. Insert AN3-12A bolt with NAS1149F0363P through bracket on lid and handle bushing on one end of handle.
  - iv. On other end of handle, hook spring over catch rivet on handle assembly and use spring tool to twist spring to catch arm on bracket on lid while inserting AN3-12A bolt with NAS1149F0363P washer through lid bracket and handle bushing.
  - v. At first end, remove bolt and repeat step iv.
  - vi. Install NAS1149F0363P washer and MS21044N3 nut on both AN3-12A bolts.
  - vii. Torque AN3 bolts to 20-25 in-lbs.
- c. Check handle *OK*
  - i. Operate handle to ensure handle does not bind and springs hold handle in.
  - ii. Snap handle into brackets to ensure handle locks.
- d. Record PO/WO of all parts used in steps above on attached material tracking list.



*AK*

5. Install lid brace

- a. Locate 36280-01 lid brace on bushing in basket. Ensure brace is on forward end of basket as it will be installed on the helicopter.
- b. On lid end, insert AN970-3 washer into end of lid brace. Insert AN3-15A bolt with NAS1149F0363P washer through AN970-3 washer, lid prop, and lid bushing. Install NAS1149F0363P washer and MS21044N3 nut on bolt.
- c. On basket end, insert AN3-17A bolt with AN970-3 washer through lid prop and basket bushing. Install NAS1149F0363P washer and MS2144N3 nut on bolt.
- d. Ensure brace is seated on lip of bushings before tightening nuts.
- e. Torque AN3 bolts to 20-25 in-lbs.
- f. Record PO/WO of all parts used in steps above on attached material tracking list.

6. 946 Basket Only: Install Cutout Brace

- a. Locate 94621-01 Brace over aft cross tube cutout.
- b. Install two AN4-6A bolts and two AN4-27A bolts with NAS1149F0463P washers.
- c. Torque AN4 bolts to 50-70 in-lbs.

*AK*

AD  
73-04  
02

7. Final Inspection

Dual inspection by a different person than assembled the basket.

- a. Check for general condition and correct assembly:
  - i. Bolts are tight
  - ii. Rivets are installed correctly
  - iii. Handle operates correctly
  - iv. Lid brace operates correctly
- b. Check that PO/WO numbers have been recorded.



Work Order: 2017-195

Date Opened: 17 Nov. 2017

Material Tracking Sheet

Bell 206L / 407

HIGH Basket Assembly

1 of 2

| Ass'y Step    | Qty | Detail Drawing | Part Number   | Description                  | Material                          | PO/WO        |
|---------------|-----|----------------|---------------|------------------------------|-----------------------------------|--------------|
|               | 1   |                | 76610-01      | <b>Cargo Basket Assembly</b> |                                   | S/N 76601-33 |
| <b>Step 1</b> |     |                |               | <i>Lid Assembly</i>          |                                   |              |
|               | 1   |                | 76612-01      | Basket Lid Assembly          |                                   | 2017-163-01  |
| Step 1.a.     | 4   |                | 49205-14      | Bumper                       | Argus Industries Bumper           | See PDS      |
|               | A/R |                | --            | Sealant                      | Commercial Silicone RTV sealant   | N/A          |
| Step 1.b.     | 1   |                | 76627-01      | Placard                      | 0.050 Sheet, 6061-T6 Aluminum     | 2015-03      |
|               | 4   |                | CR3213-4-02   | Cherry Rivet                 |                                   | 17070        |
| Step 1.c.     | 1   |                | 70405-01      | Lid Step Modification        |                                   |              |
| (option)      | 1   |                | 70405-04      | Tread Plate                  | 3003 Aluminum Tread Plate, 0.063" | 17081        |
|               | A/R |                | CR3213-4-02   | Cherry Rivet                 |                                   | 17070        |
|               | A/R |                | --            | Sealant                      | Commercial Silicone RTV sealant   | N/A          |
| <b>Step 2</b> |     |                |               | <i>Basket Assembly</i>       |                                   |              |
| Step 2.a.     | 1   |                | 76611-01      | Basket Body Assembly         |                                   | 2017-163-01  |
|               | 4   |                | 96710-01      | Fitting                      | Alternate: Ancra 40088-14         | See PDS      |
|               | 8   |                | NAS1149F0663P | Washer                       |                                   | See PDS      |
| <b>Step 3</b> |     |                |               | <i>Hinge Installation</i>    |                                   |              |
|               | 1   |                | MS20001P4     | Piano Hinge                  | 90"                               | 17017        |
|               | 8   |                | CR3523-5-02   | Cherry Rivet                 |                                   | 16063        |
|               | A/R |                | CR3213-5-02   | Cherry Rivet                 |                                   | 16053        |
| <b>Step 4</b> | 1   | 84255          | 84255-01      | <i>Handle Installation</i>   |                                   |              |
| Step 4.a.     | 2   |                | 84267-01      | Bracket                      | Delrin, 3/4" Sheet                | 2017-150     |
|               | 4   |                | AN3-11A       | Bolt                         |                                   | See PDS      |
|               | 8   |                | NAS1149F0363P | Washer                       |                                   | See PDS      |
|               | 4   |                | MS21044N3     | Nut                          |                                   | See PDS      |

Rev 1  
17 Nov. 17

Work Order: \_\_\_\_\_

## Material Tracking Sheet

2 of 2

Bell 206L / 407

Date Opened: \_\_\_\_\_

## HIGH Basket Assembly

| Ass'y Step | Qty  | Detail Drawing | Part Number   | Description              | Material                            | PO/WO    |
|------------|------|----------------|---------------|--------------------------|-------------------------------------|----------|
| Step 4.b.  | .. 1 |                | 84261-01      | Handle Assembly          |                                     | 2017-194 |
|            | .. 2 |                | 36278-01      | Spring (1 left, 1 right) | 304 Stainless, 1/16" Dia Music Wire | See PDS  |
|            | .. 2 |                | 36275-01      | Bushing                  | Brass, 5/16" Dia                    | See PDS  |
|            | .. 2 |                | AN3-12A       | Bolt                     |                                     | See PDS  |
|            | .. 4 |                | NAS1149F0363P | Washer                   |                                     | See PDS  |
|            | .. 2 |                | MS21044N3     | Nut                      |                                     | See PDS  |
| Step 5     |      |                |               | Lid Brace Installation   |                                     |          |
|            | . 1  |                | 84280-01      | Brace Assembly           |                                     | 2017-170 |
|            | . 1  |                | AN3-15A       | Bolt                     |                                     | See PDS  |
|            | . 1  |                | AN3-17A       | Bolt                     |                                     | See PDS  |
|            | . 2  |                | AN970-3       | Washer                   |                                     | See PDS  |
|            | . 3  |                | NAS1149F0363P | Washer                   |                                     | See PDS  |
|            | . 2  |                | MS21044N3     | Nut                      |                                     | See PDS  |
| Step 6     |      |                |               | Inspection               | None                                |          |

17 Nov 17  
Rev 1

## Aero Design

### Parts Distribution Sheet

**Description:** Basket Assembly Kit

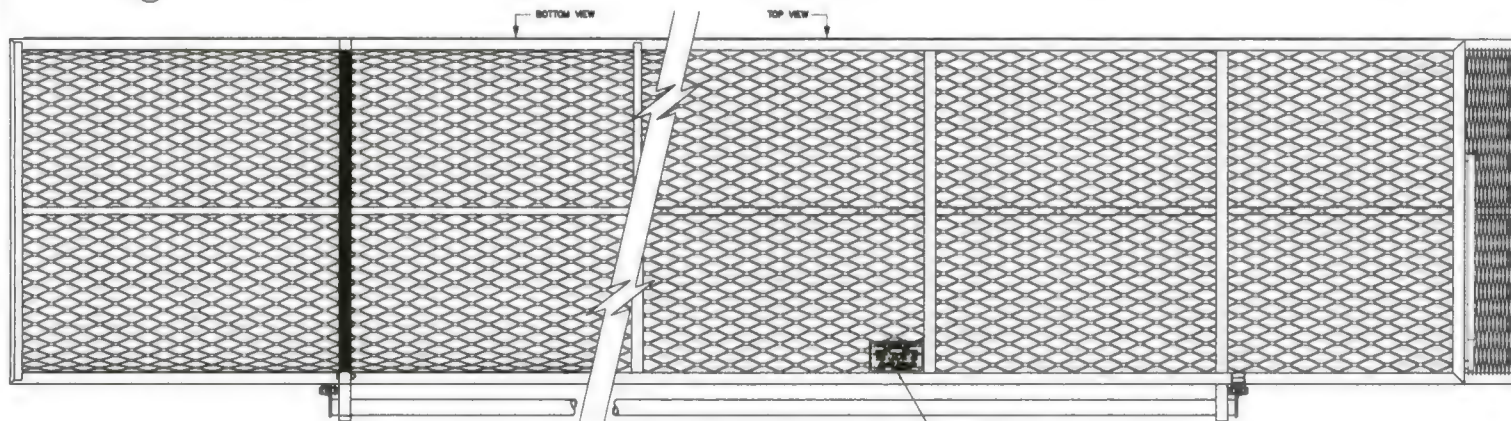
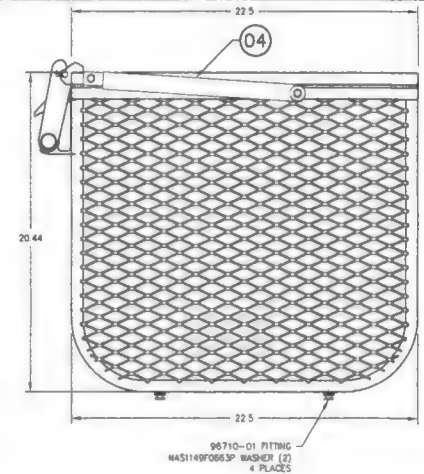
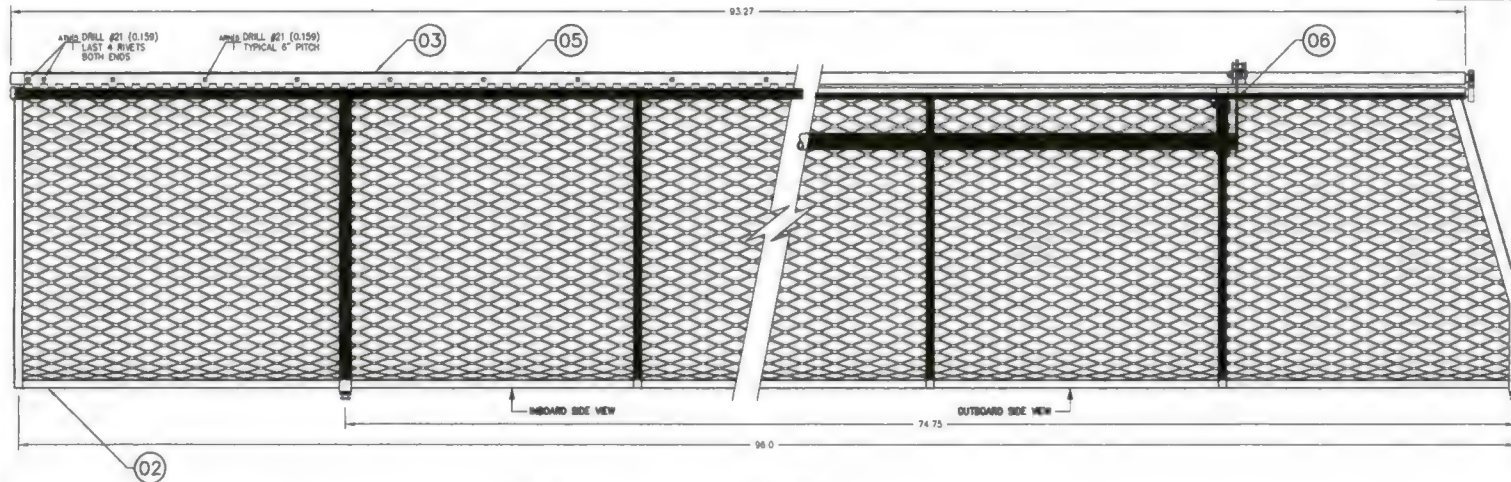
200 CB  
WO# 2017-195

[illegible]



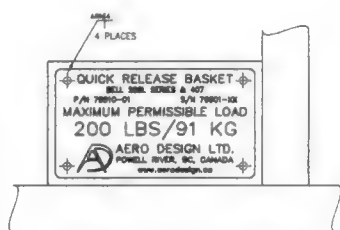
2017-200

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|--|--|----------|------------|
| REV  | DESCRIPTION OF CHANGE  | INITIALS | DATE       |
| 0  | CREATED FROM 60630   | BUC      | 25/08/2007 |
| 1  | TITLE BLOCK UPDATED, HANDLE UPDATED TO 842 CONFIGURATION     | BUC      | 25/08/2017 |
|  | PLACARD UPDATED AND MOVED TO OPPOSITE SIDE, HARDWARE UPDATED |          |            |
|  | ATTACHMENT HOOPS UPDATED                                     |          |            |



NOTE  
1 ALL DIMENSIONS SHOWN ARE FOR REFERENCE ONLY. DIMENSIONS OF COMPONENTS AND COMPLETE ASSEMBLY ARE DETERMINED IN PREVIOUS STEPS.

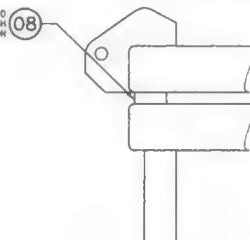
01 CARGO BASKET ASSEMBLY



DETAIL B

SCALE 1 : 1  
LOOKING AT PLACARD BRACKET

DRILL 0.25 INTO LID  
ENSURE CLEARANCE FROM MESH  
4 PLACES MIN







BUMPER INSTALLATION

SCALE 1 : 1

| QTY. | PART NO.      | ITEM | DESCRIPTION             | MATERIAL           |
|------|---------------|------|-------------------------|--------------------|
| 4    | CR3213-4-02   |      | CHERRY RIVET            | ALT HR3213-4-02    |
| 8    | CR3213-5-02   |      | CHERRY RIVET            | ALT HR3213-5-02    |
| A/R  | CR3213-5-02   |      | CHERRY RIVET            | ALT HR3213-5-02    |
| 1    | NAS1149F0653P |      | WASHER                  |                    |
| 4    | 96710-01      |      | FITTING                 | ALT ANCR4 4088B-14 |
| 1    | 49205-14      | BB   | BUMPER                  | ARGUS INDUSTRIES   |
| 1    | 76627-01      | 07   | PLACARD                 |                    |
| 1    | 84235-01      |      | HANDLE BAR INSTALLATION |                    |
| 1    | MS20001P4     | 05   | PIANO HINGE             | 90 INCHES          |
| 1    | 84240-01      | 04   | BRACE INSTALLATION      |                    |
| 1    | 60632-01      | 03   | LID ASSEMBLY            |                    |
| 1    | 76611-01      | 02   | BASKET BODY ASSEMBLY    |                    |
| 1    | 76610-01      | 01   | CARGO BASKET ASSEMBLY   |                    |

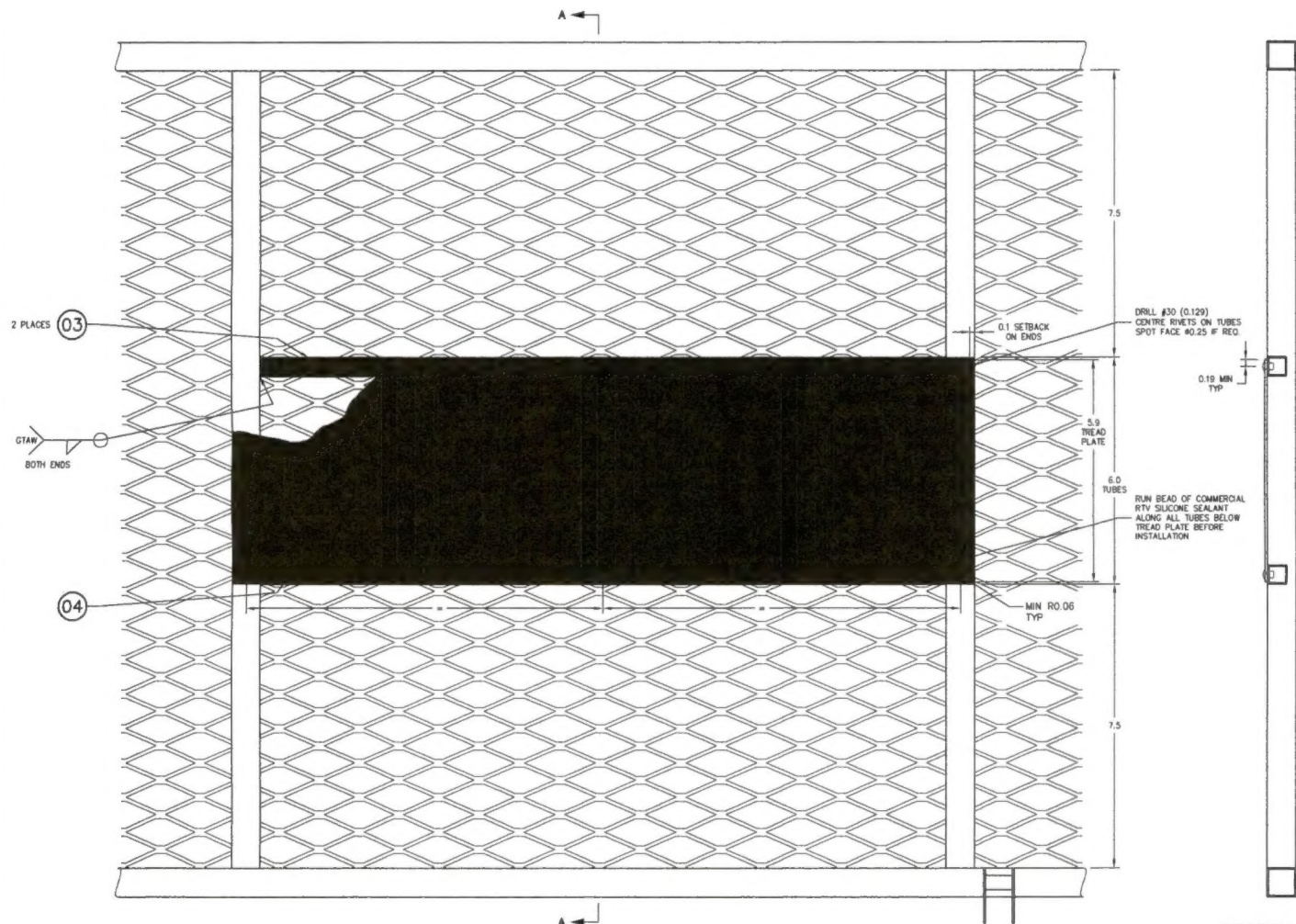
LIST OF MATERIALS

|   |  |   |  |  |                 |                             |   |                          |                 |
|---|--|---|--|--|-----------------|-----------------------------|---|--------------------------|-----------------|
| BASIC CODE<br>REF: HAS 323  |  | DASH NO. FOR DIAMETER<br>H=HOLE<br>W=HEAD<br>F=FLANGE<br>D=DRILL  | DASH NO. FOR DIAMETER<br>H=HOLE<br>W=HEAD<br>F=FLANGE<br>D=DRILL | APPROVALS  |                 | DATE                        |  <b>AERO DESIGN LTD.</b><br>8888A MALASPINA ROAD<br>POWELL RIVER, BC, CANADA, V8A 0G3<br>TEL: 604.683.2276 www.aerodesign.co |                          |                 |
| C=COUNTERSINK<br>D=DRILL<br>DIST=# OF SHEETS<br>TO BE DRILLED                     |  | DASH NO. FOR LENGTH   | DASH NO. FOR LENGTH  | DRAWN  | JEFF CLARKE     | 25 SEPT 2007                |   |                          |                 |
|   |  |   |  | CHECKED  | E. BURGON       | 27 SEPT 2007                |   |                          |                 |
|   |  |   |  | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES<br>TOLERANCES ON: |                 |                             |   |                          |                 |
| BASIC CODES<br>BS = WSS2407AD<br>SB = WSS2407AD<br>ARN = CR35213<br>ATM = CR35213 |  |  INSTALL NEW RINET<br> REMOVE/REPLACE RINET<br> EXISTING RINET |  | DECIMALS<br>X XXX ±0.010<br>X XX ±0.03<br>X X ±0.1                       | ANGLES<br>±1/2° | SCALE 1 : 4<br>SHEET 1 OF 1 | DWG. SIZE<br><b>A1</b>  | DWG. NO.<br><b>76610</b> | REV<br><b>1</b> |



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| REV | DESCRIPTION OF CHANGE   | INITIALS | DATE       |
|-----|---|----------|------------|
| 1   | ADD BELL MEDIUM AND EUROCOPTER AS350 BASKETS, CHANGE TUBES          | BJC      | MAR 19/08  |
| 2   | ADD EUROCOPTER EC135, MCDONNELL DOUGLAS MD600N, BELL 206B BASKETS   | BJC      | DEC 4/08   |
| 3   | ADD NEW AS350 AND 206L/407 MODELS                                   | BJC      | DEC 4/08   |
| 4   | TITLE BLOCK UPDATED; MODEL LIST REMOVED; ADD ALTY RIVET; ADD NOTE 7 | BJC      | 29/05/2014 |



(01) BASKET LID ASSEMBLY

SECTION A-A

NOTES:

1. THIS DRAWING IS AN OPTIONAL CONFIGURATION ADDING A TREAD PLATE STEP TO THE LD. THIS CONFIGURATION MAY BE APPLIED TO ANY OR ALL BAYS OF THE LD. REMAINDER OF LD ASSEMBLY IS TO BE FABRICATED IN ACCORDANCE WITH THE APPLICABLE DRAWINGS.
2. TUBES (ITEM 03) MUST BE WELDED IN PLACE BEFORE MESH IS WELDED ON BOTTOM.
3. REMOVE ALL BURRS AND BREAK SHARP EDGES.
4. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2885C. WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
5. WHEN ASSEMBLY IS COMPLETE, FILL ALL VENT HOLES WITH ROSETTE WELD.
6. THOROUGHLY CLEAN AND POWDER COAT BASKET SUB-ASSEMBLIES PRIOR TO ASSEMBLY. INSTALL TREAD PLATE AFTER POWDER COATING.
7. WIDTH AND POSITION OF LD STEP MAY BE ADJUSTED TO MATCH LD DOOR INSTALLED IN ACCORDANCE WITH DRAWING 70402 ON ADJOINING BAY OF THE LD.

|     |             |   |                        |                       |
|-----|-------------|---|------------------------|-----------------------|
| A/R | CR3213-4-02 | BLIND RIVET                                 | ALTERNATE: HR3213-4-02 |                       |
| 1   | 70405-04    | 04 TREAD PLATE                              | ALUMINUM               | COMMERCIAL            |
| 2   | 70405-03    | 03 TUBE                                     | 4130 STEEL COND. N     | MIL-T-8735            |
| 1   | SEE NOTE 1  | 02 BASKET LID ASSEMBLY                      |                        | 0.063 TREAD PLATE     |
| 1   | 70405-01    | 01 BASKET LID ASSEMBLY - MODIFIED WITH STEP |                        | 0.5 X 0.035 WALL TUBE |
| D1  | PART NO.    | ITEM  | DESCRIPTION            | MATERIAL              |
| QTY |             |   |                        | MATERIAL SPEC         |
|     |             |   |                        | STOCK SIZE            |

| BASIC CODE        |  | DASH NO. FOR DIAMETER  |  | APPROVALS                  |  | DATE         |  |
|-------------------|--|------------------------|--|----------------------------|--|--------------|--|
| REF. NAS 523      |  | N=MFD. HEAD NEAR SIDE  |  | DRAWN: JEFF CLARKE         |  | 21 SEPT 2006 |  |
| C=COUNTERSUNK     |  | F=MFD. HEAD FAR SIDE   |  | CHECKED: E. BURGOIN        |  |              |  |
| D=DIMPLE          |  | DASH NO. FOR LENGTH    |  | UNLESS OTHERWISE SPECIFIED |  |              |  |
| DIGIT=# OF SHEETS |  |                        |  | DIMENSIONS ARE IN INCHES.  |  |              |  |
| TO BE DIMPLED     |  |                        |  | TOLERANCES ON:             |  |              |  |
| BASIC CODES:      |  |                        |  | DECIMALS                   |  |              |  |
| BJ=MS20470AD      |  | + INSTALL NEW RIVET    |  | ANGLES                     |  |              |  |
| BB=MS20426AD      |  | + REMOVE/REPLACE RIVET |  | X.XXX ±0.010               |  |              |  |
| ARN=CR3213        |  | - EXISTING RIVET       |  | X.XX ±0.03                 |  |              |  |
| ARN=CR3212        |  |                        |  | X.X ±0.1                   |  |              |  |

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**CARGO BASKET**

**LD STEP MODIFICATION**

|               |             |                |        |
|---------------|-------------|----------------|--------|
| SCALE 1 : 1.5 | DWG. NO. A1 | DWG. NO. 70405 | REV. 4 |
| SHEET 1 OF 1  |             |                |        |





| REV. | DESCRIPTION OF CHANGE   | INITIALS | DATE       |
|------|---|----------|------------|
| 0    | INITIAL ISSUE - 76625   |          |            |
| 1    | DWG # CHANGED TO 76627; UPDATE TITLE BLOCK; UPDATE ADDRESS AND LOGO | BJC      | 09/08/2016 |
|      | MAT'L THICKNESS CHANGED; P/N ADDED                                  |          |            |

# NOTES


## 1. ENGRAVE 0.007 DEEP AS FOLLOWS:

- "QUICK RELEASE BASKET" - 0.125 HIGH
- "BELL 206L SERIES & 407" - 0.080 HIGH
- "P/N 76610-01 S/N 76601-XX" - 0.080 HIGH
- "MAXIMUM PERMISSIBLE LOAD" - 0.125 HIGH
- "200 LBS. TOTAL" - 0.200 HIGH
- "AERO DESIGN LTD." - 0.125 HIGH
- "POWELL RIVER, BC, CANADA" - 0.080 HIGH
- "www.aerodesign.ca" - 0.080 HIGH

DRILL #30 (0.129)  
4 PLACES

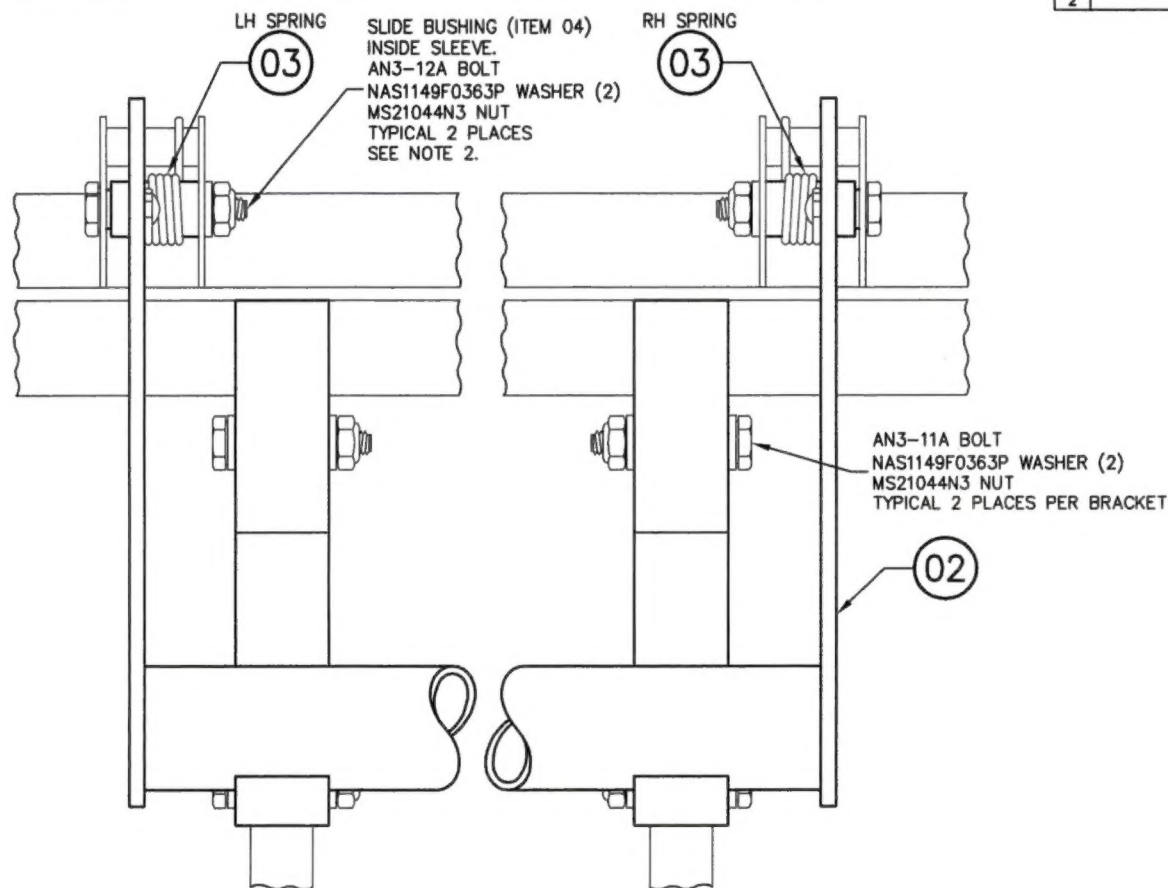


01 PLACARD

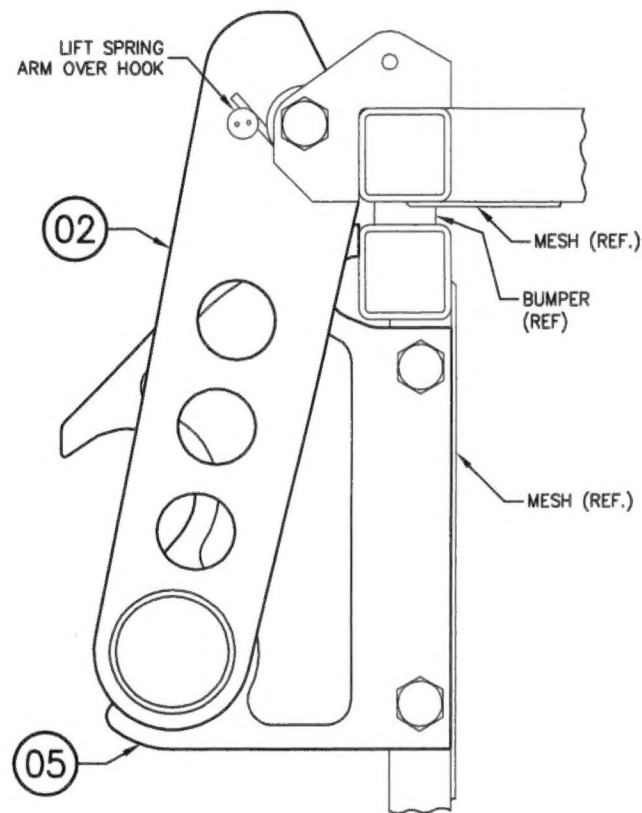
|   |   |      |              |   |               |            |          |      |   |  |
|---|---|------|--------------|---|---------------|------------|----------|------|---|--|
| 1   | 76627-01  | 01   | PLACARD      | 6061-T6 ALUMINUM  | QQ-A-250/11   | 0.05 SHEET |          |      |   |  |
| 01  | PART NO.  | ITEM | DESCRIPTION  | MATERIAL  | MATERIAL SPEC | STOCK SIZE |          |      |   |  |
| QTY   | LIST OF MATERIALS   |      |              |   |               |            |          |      |   |  |
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|   | DRAWN: JEFF CLARKE  |      | 09 AUG 2016  |   |               |            |          |      |   |  |
|   | CHECKED: JASON REKVE  |      | 09 AUG 2016  |   |               |            |          |      |   |  |
|   | UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES.<br>TOLERANCES ON: |      |              | <b>BELL 206L SERIES AND 407<br/>QUICK RELEASE HIGH MOUNTED CARGO BASKET<br/>PLACARD</b>   |               |            |          |      |   |  |
|   | DECIMALS  |      | ANGLES       |   |               |            |          |      |   |  |
|   | X.XXX ±0.010  |      | ±1/2"        |   |               |            |          |      |   |  |
|   | X.XX ±0.03  |      |              |   |               |            |          |      |   |  |
| X.X ±0.1  |   |      | SCALE 1 : 1  |   |               | DWG. SIZE  | DWG. NO. | REV. |   |  |
|   |   |      | SHEET 1 OF 1 |   | A1            |            | 76627    |      | 1 |  |

NOTES:

1. THIS DRAWING IS AN ALTERNATE CONFIGURATION FOR THE HANDLE INSTALLATION SHOWN ON DRAWING 36255.
2. GREASE BUSHING (ITEM 04) USING MOBILGREASE 28 OR EQUIVALENT PRIOR TO INSTALLATION.



01 HANDLE INSTALLATION



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|---|---|----------|------------|
| REV.  | DESCRIPTION OF CHANGE                             | INITIALS | DATE       |
| 0   | INITIAL ISSUE - CREATED FROM 36255                | BJC      | NOV 03/09  |
| 1   | HANDLE END BRACKETS FLIPPED                       | BJC      | SEPT 19/11 |
| 2   | TITLE BLOCK UPDATED; ADD NOTE 2; HARDWARE UPDATED | BJC      | MAR 13/14  |

|      |                   |      |                     |                |
|------|-------------------|------|---------------------|----------------|
| A/R  | MOBILGREASE 28    |      | GREASE              | MIL-PRF-81322F |
| 4    | AN3-11A           |      | BOLT                |                |
| 2    | AN3-12A           |      | BOLT                |                |
| 10   | NAS1149F0363P     |      | WASHER              |                |
| 6    | MS21044N3         |      | NUT                 |                |
| 2    | 84267-01          | 05   | BRACKET             |                |
| 2    | 36275-01          | 04   | BUSHING             |                |
| 2    | 36278-01          | 03   | SPRING (1 LH, 1 RH) |                |
| 1    | 84261-01          | 02   | HANDLE BAR ASSEMBLY |                |
|      | 84255-01          | 01   | HANDLE INSTALLATION |                |
| 01   | PART NO.          | ITEM | DESCRIPTION         | MATERIAL       |
| QTY. | LIST OF MATERIALS |      |                     |                |

| APPROVALS   | DATE        |
|---|-------------|
| DRAWN: JEFF CLARKE  | 03 NOV 2009 |
| CHECKED: E. BURGOIN   |             |
| UNLESS OTHERWISE SPECIFIED<br>DIMENSIONS ARE IN INCHES.<br>TOLERANCES ON: |             |
| DECIMALS  | ANGLES      |
| X.XXX ±0.010  | ±1/2°       |
| X.XX ±0.03  |             |
| X.X ±0.1  |             |

|   |          |  |      |
|---|----------|--|------|
|  <b>AERO DESIGN LTD.</b><br>9888A MALASPINA ROAD<br>POWELL RIVER, BC, CANADA, V8A 0G3<br>TEL: 804.483.2376 www.aerodesign.ca |          | <b>HELICOPTER CARGO BASKET<br/>HANDLE BAR INSTALLATION</b> |      |
|   |          | SCALE 1 : 1  | REV. |
| DWG. SIZE   | DWG. NO. | SHEET 1 OF 1   |      |
| A3  | 84255    | 2  |      |